

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007011**Date Inspected:** 28-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Makhmud Ashadi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 5/28/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections and their associated built up plate sections in the Fabrication shop #4 and Foundry at Japan Steel Works, Muroran, Hokkaido, Japan.

**WEST DEVIATION SADDLES**

W2E3 - Built up Saddle section is undergoing a Magnetic Particle (MT) inspection in Fabrication shop #4. Following Post Weld Heat Treat, identified indications are being ground for further evaluation. Method was continuous method, with Dry Powder (red), field induction by contour probe. Technician Mr. R.Kumagai #132 was using a pie gage to verify efficiency of field strength. Inspection process continued through QA Inspector's shift.

W2W1 - Saddle section, still joining cast to plate section, in Fabrication Shop #4. Joint W1S-2U, which joins the plate stem to Cast stem is now having side 1 passes deposited by welders M.Kashiwada 08-2008, T.Kawakami 08-5079 and Y.Maeyama 94-5234 each were positioned between plate ribs 4-15~4-17, 4-4~4-5, 4-9~4-11 respectively. Mr. Makhmud Ashadi verified parameters upon taking over for Mr. Chung Fu Kuan as QC CWI for the evening shift. Welders remain same through QA Inspectors shift.

W2W2 - Saddle Cast section is relocating from Machine Shop #2, and is expected to arrive in Fabrication Shop by Friday. Built up plate portion has been relocated to be shot blasted following its Intermediate Stress Relief.

W2W3 - Saddle Casting is located in Foundry, idle. Built up portion is having reinforcement ground by JSW personnel to better suit NDE and to remove possible surface notches left between beads, the grinding continued through to end of QA Inspector's shift.

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## WELDING INSPECTION REPORT

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### TOWER SADDLES

T1-2 - During the QA Inspector's observance of Tower Saddle T1-2, JSW personnel were actively rotating the Saddle section (in Fabrication Shop #4) preheat will commence with no welding expected to resume until am.

T1-3 - Saddle is in process of being joined to its steel plate portion in Fabrication Shop #4. QA Inspector observed JSW personnel also preparing to rotate saddle section preparing the welds for NDE, both MT and UT will be completed to welds joining cast section to its built up plate section.

### EAST DEVIATION SADDLES

E2E1 - Magnetic Particle inspection and Dye Penetrant inspection is complete and saddle casting is awaiting Ultrasonic testing to determine the condition of the as casted saddle, in Foundry Shop.

E2W1 - The Casted Saddle section is through having excavations evaluated, sized and classified. An ECS is being prepared by JSW, per JSW Representative, Mr. Hideaki Kon.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

#### Summary of Conversations:

No significant conversations to report on this day.

#### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Brcic,Michael	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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